

Date: Friday, 29/08/2008 11:39:17 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLATE
Job Number	: 41680		
Estimate Number	: 10424		
P.O. Number	:	Part Number	: D33031
This Issue	: 29/08/2008 S.O. No. :	Drawing Number	: D3303 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 41219	Material	:
Written By	:	Due Date	: 05/09/2008 Qty: 16 Um: Each
Checked & Approved By	: <u>JUL 08.8.29</u>		
Comment	: Est:A 04.09.07 New issue KJ/JLM Est Rev:B 06-06-28 Now On Waterjet JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S032	2024-T3 .032 sheet
-----	-------------	--------------------



8.



Comment: Qty.: 0.3719 sf(s)/Unit Total : 5.9506 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.032" thick

(M2024T3S.032)

Batch: 108595 B8-9-8

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3303

Dwg Rev: BProg Rev: BB8-9-8

(19)

2-Deburr if necessary

B8-9-8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B8-9-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8 00/09/0819

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1108-09-0819

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 29/08/2008 11:39:17 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 41680

Part Number: D33031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



19X

Comment: INSPECT CHEMICAL CONVERSION COAT

M-B

08/09/07

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 83

SS

08/09/08

(19)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/09/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41680
<b>Description:</b> Plate		<b>Part Number:</b> D3303-1
<b>Inspection Dwg:</b> D3303 <b>Rev:</b> B		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

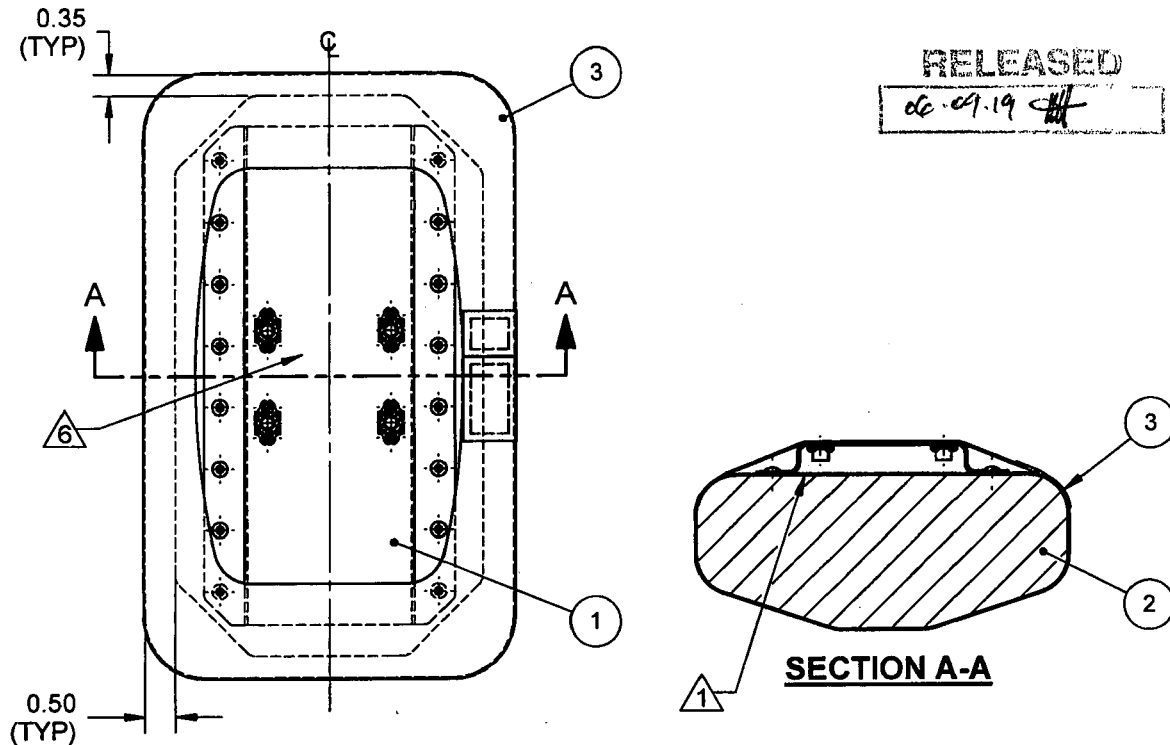
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.00	+/-0.030	5.011	X			
3.550	+/-0.005	3.553	X			
1.22 x 45°	+/-0.030	1.22	X			
R0.25	+/-0.030	.25	X			
9.10	+/-0.030	9.10	X			
7.000	+/-0.005	6.998	X			
1.000	+/-0.005	1.000	X			
1.050	+/-0.010	1.052	X			
0.725	+/-0.010	.730	X			
0.032	+/-0.010	.031	X			
Ø0.129	+0.004/-0.001	.131	X			

<b>Measured by:</b> HB	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-9-8	<b>Date:</b> 08/09/08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	
B	07.01.16	5.00 was 5.000; Ø0.129 added	KJ/JLM	

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

**NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

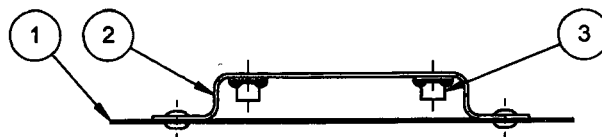
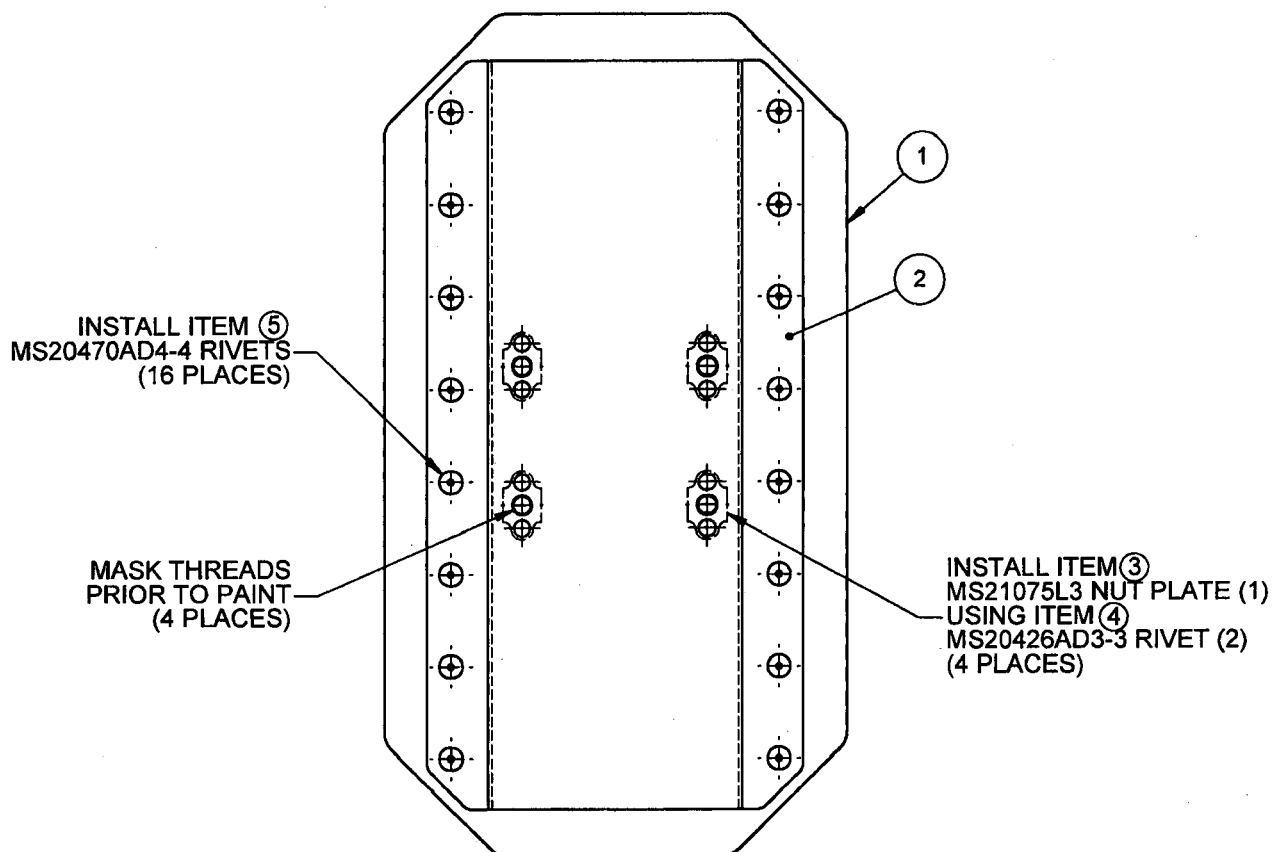
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41680

**COPYRIGHT © 2004 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 2 OF 4
DATE <b>06.08.17</b>		TITLE <b>HEAD REST</b>	SCALE 1:2

**RELEASED***06.09.19***D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

**NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

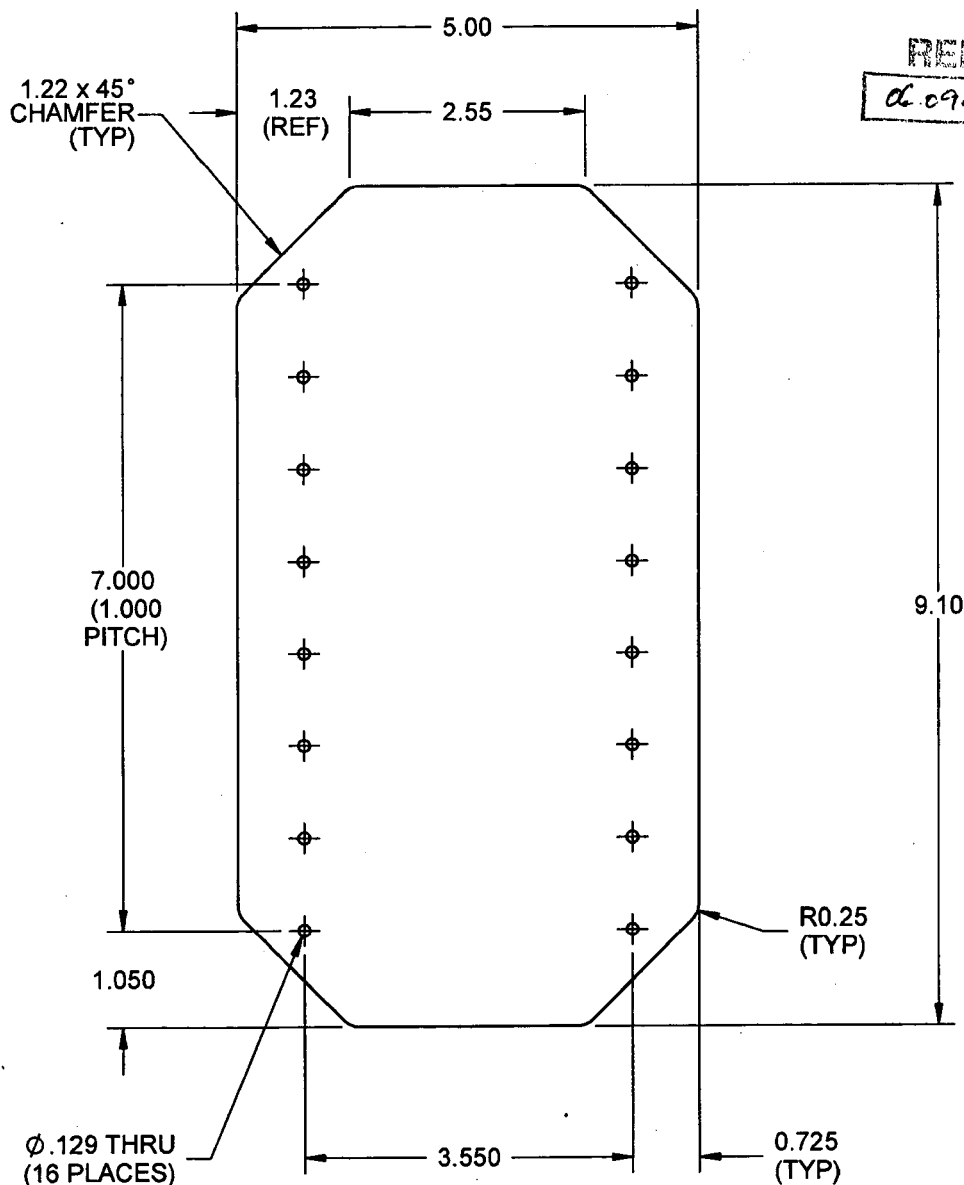
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. *41680*

**COPYRIGHT © 2004 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



### D3303-1 PLATE

#### NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *41680*

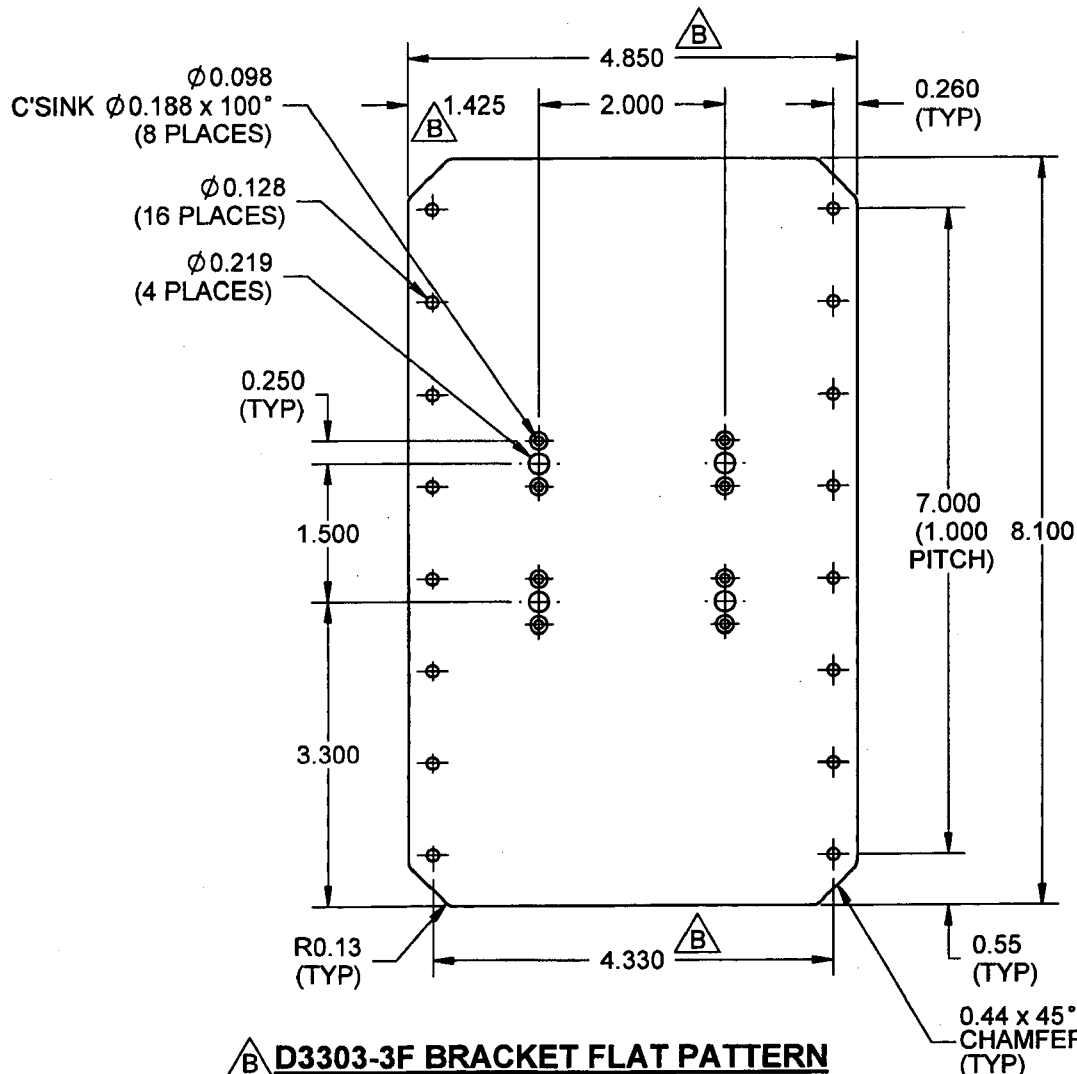
COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



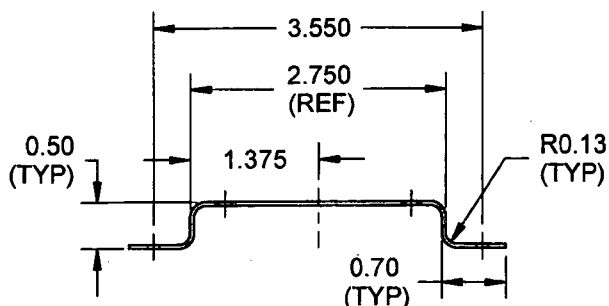


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED  
06.09.19

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41680



**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

COPYRIGHT © 2004 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.